

	Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200	PC250-500 Job Sheet 177439 					
Part No: PC250-500 Job Qty: 3 ea Part Name: Lock 							
Part Weight: 0 lbs Status: At Planning Priority: High Job Created: 5/11/18 Job Tracking No: Due Date: 5/11/18 Created By: Logan David Type: SOLD Description: Note: DWG PC250-500 REV:1 IPP REV A 18.02.28 NEW ISSUE RQ VERIFIED BY DP Ship Via:							
Bill of Materials							
Job Routing							
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier Workcenter / Supplier Lead Time	Sign-off
90	Start up Operation	3 Ea	5/11/18	5/11/18	0.00 0.00	Start Up Machining-4	18/05/26
120	CNC Vertical Machining	3 pcs	5/11/18	5/11/18	0.50 3.00	MORI NV5000-1	18/05/26
130	QC	3 pcs	5/11/18	5/11/18	0.00 0.00	QC2 Machining-5	18-05-28
140	QC	3 pcs	5/11/18	5/11/18	0.00 0.00	QC8 Machining-5	18-05-30
150	Packaging	3 pcs	5/11/18	5/11/18	0.00 0.00	Packaging3-2	GA-Akin 18-05-31
160	QC21-FG	3 Ea	5/11/18	5/11/18	0.00 0.00	QC21	21 MAY 31 2018
Part Op 120 - Cut Blanks at _____ 1-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____ 2- Descriptions: Machine engrave Batch# _____ 3-Debur 130 - 150 - Identify and Stock							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
M17-4-H900-B2.250X3.000	17-4 SS H900 Bar 2.250" X 03.000"	1.8750 ft (.625 ea)	90-Start up Operation	5075179			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
90-Start up Operation	M17-4-H900-B2.250X3.000	2	5	0			
Part Specifications							
Specifications could not be found.							

DAVID
 DWAL
 JEAN
 FRANÇOIS
 SAUVE

Plex 5/11/18 9:17 AM dart.logan.david

DART
AEROSPACE

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Container No: S075183



Part: PC250-500

Job No: 177439

Serial No/Batch: S075183

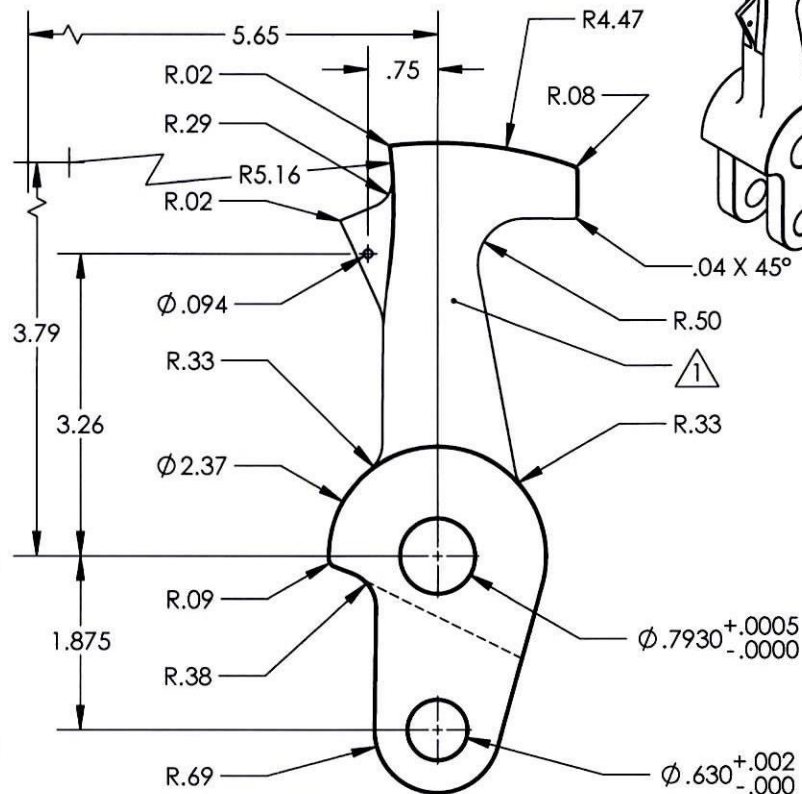
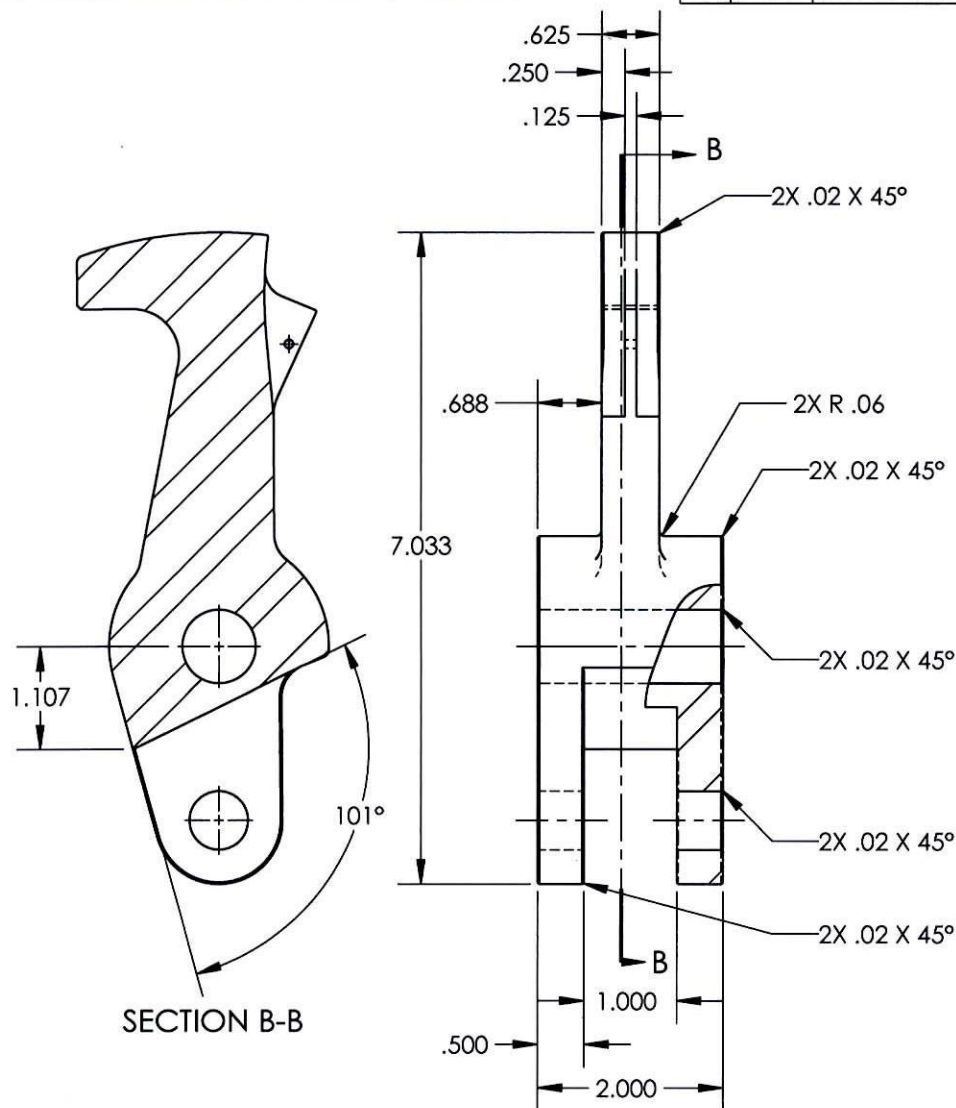
Revision: 1

Inspector:

Date: 06/29/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0128	PC250-500 ADDED MACHINE ENGRAVE NOTE.	8/14/2014	DPD	RW



NOTE:

△ MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK ASSEMBLY	
DWG NO. PC250-500A	REV 1
MATL 4140	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT TREAT HRC 42-44
.XX ± .01	FINISH SEE SHEET 1, NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 5/20/2004 SHEET 2 OF 3

SHOP COPY
RETURN TO
ENGINEERING

FOR A COPY OF THIS COPY
SUBJECT TO THE FOLLOWING
WITHOUT NOTICE
WORK ORDER

(PC250-500)

LOCK

NO. **177439**
20180511

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

